

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011722**Date Inspected:** 29-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (6CW)

This QA inspector witnessed final tension verification for lower chevron and upper chevron of Segment 6CW. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP 44, PP 45, PP 46, PP 47: M22 X 70 – DHGM 220020 – 520 NM, M22 X 80 – DHGM 220012 – 427 NM

PP 44 (N), PP 46 (S & N), PP 47 (N): M22 X 75 – DHGM 220005 – 473 NM

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed longitudinal diaphragm dimensional survey along with ABF for below segments. Reports forwarded to team leader for further action

6BE-6CE (CB side)

OBG # TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector performed U-Rib dimensional survey along with ABF for below segments. Reports forwarded to team leader for further action

7AE-7BE

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed longitudinal diaphragm dimensional survey for below segments. Reports forwarded to team leader for further action

6BW-6CW

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6CW)

SMAW Process:

Welding of weld joint –043 located on PCMK SEG031*, corner assembly longitudinal weld joining Edge panel and Side panel of 6CW. Welder is identified as 067610. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (7AW)

SMAW Process:

Welding of weld joint –005 located on PCMK CA032, corner assembly longitudinal weld joining Edge panel and Side panel of 7AW. Welder is identified as 067943. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6CW-7AW)

SMAW Process:

Welding of weld joint –007 located on PCMK SEG033A, longitudinal weld joining bottom and side panel at work point W4 of 7AW. Welder is identified as 067949. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR10059. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
----------------------	--------------------

Quality Assurance Inspector

Reviewed By:	Miller,Mark
---------------------	-------------

QA Reviewer
